Work Orde Wednesday, Octo				*90	257*				Page 1			
Revision ID:	D350-636-01			Accept	Setup Star	1 /1	S1*					
Item Name:	Skidtube STD	w/ Training Wearplates	, RH							Stop	*N	S2*
Required Date:	9/13/2012 9/28/2012 ECN 12-650	Start Qty: 1.00 Req'd Qty: 1.00 LEWORK	*1* *1*	Cust Item ID: Customer:								
Approvals:	Process Pla	n: MF	Date: 2-10-4,	Tooling:		Date:			R	Run Star	1/1	R1*
	QC:		Date:	SPC (Y/N):						Stop	° *N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	To	ool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr							1 10 1 4	<u></u>	W I	
D3492	C	1							134	ø	JU	u (110/25
IIN-D350-636	A I		^									
290				0.00								
290 HandFinish		Memo	1	0.00							TOTAL PROPERTY AND ALL	- 14 FE
Hand Finishing			1 STOCK D350-636-016 2	KIB#81400 CHG	5002							
			4154-041 AND SCRAP /ITH NEW D4154-041 (R	EV E)								
		, KLI LACE W	7111 ŊEW D4134-041 (K	ŕ								
300		QC5- Inspect part comple	teness to step on W/O	0.00	DAS 15 DD3							
300 QC Quality Control		Мето		0.00	D.JS							
CERTIFICATION ON CONTROVERS	1KV	IBAPTIDVAL #09 Till: 1-6184682452										
D350-636-01 Skidtube RI	6	GIG CHG002 SIG SH99-7	_					:				-

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AS350/355

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												DQA:_	Da	ιe. ₋	
NCR:	Yes ,	/ No				WORK ORDER NON-C	O	NFORN	/IANCE / UPI	DATE	QA	Closed:	Da	te:	
Work Orde	er.					DISPOSITION		AGAINST DE	AGAINST DEPARTMENT/PROCESS						
Part N	Part No					Scrap Machining Small Use-as-is Thermoforming Finish			Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier				Engineering Quality Other	
Root			·		Descri	ption of work order update	1	nitial	Act	ion	S	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date Verification			n	QC Inspector
Doc/Data									1						
Equip/Tooling									İ						,
Operator					-		1								
Material											'				
Setup															
Other	Ш														
Process	Ш														
Supplier	Ш											ŀ			
Training	Ш											İ	•		
Unapproved											<u> </u>				
							AUL	T CATE	GORY						
Landi	$\overline{}$					General	_	1		_	٦.			_	1
	-	ending			.	Bend	<u> </u>	Grain		_	-	alized		-	Pressure/Forced
	\vdash	entre No	t Concer	ntric to	O/S	BOM/Route	<u> </u>	Hardwa		-	┥	er/Under 1		\vdash	Temperature/Cure
	—	racks				Broken/Damaged	-	4 `	ion Incomplete		-	rt Incorrec		_	Weld-
	-	rushed/0	Crimped		<u> </u>	Burrs	_	4	tions Incomplete/l	Unclear	⊣ .	rt Lost/Mis	ssing		Wrong Stock Pulled
	\vdash	uffs			-	Contamination	\vdash	Mainte		<u> </u>	⊣	rt Moved			
	\vdash	leat Trea				Countersink	-	Mislabe				sitioned W	_] _{0*5} ==
	-	nspection	•	lube	<u> </u>	Cut Too Short	-	Misread	1.	L	140	wer Loss/S	surge		Other
	l IR	lipples in	Bend		i	Drill Holes	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Ord Wednesday, Oct				*902					Page			
Item ID: Revision ID:	D350-636-0	16		Accept	*N900	040	100)*	Setup S	Start	*N	S1*
Item Name:	Skidtube STD	w/ Training Wearplates	, RH						S	Stop	*NI	S2*
Start Date:	9/13/2012	Start Qty: 1.00	*1*		Cust Item ID: Customer:						1 1	. 1/
Required Date:	9/28/2012	Req'd Qty: 1.00	*1*									
Reference:	ECN 12-650	1	•									
Approvals:	Process Pla	ın:	Date:	Tooling:	Tooling: Dat		ate:			Start	*N	R1*
	QC:	·	Date:	SPC (Y/N):	Date:				S	Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Iumber	Insp. Stamp
310		Identify as per dwg & Sto	ock Location:	0.00				••				1
310 Packaging		Memo		0.00							12/10	1263
Packaging			12 10-	.JK								
		UPDATE PA	APERWORK	TCH NUMBER AND NEV	JES VI	HOLD	пω	12-10-				

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

320

320

Quality Control

10,10-31

											DQ	4: D	ate:			
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	/ANCE / UPI	DATE	QA Close	d: D	ate:			
Mank Ond					-	DISPOSITION		AGAINST DEPARTMENT/PROCESS								
	Part No					Rework Scrap Use-as-is Work Order Update	Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Je rod. Eng. Coo tore/Packagin Supplie	r	Engineering Quality Other			
Root					Descri	otion of work order update		Initial	Act	ion	Sign &					
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verificati	on	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													-			
						F	AUL	T CATE	GORY							
Landi	ing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs					General Bend BOM/Route Broken/Damaged Burrs Contamination	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Part Incor Part Lost, Part Mov	'Missing ed	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled				
	\vdash	Heat Trea		- 1	<u> </u>	Countersink	-	Mislabe		-	Positione Power Lo	-		Other		
	-	Inspectio Ripples ir	•	ıupe		Cut Too Short Drill Holes	\vdash	Misread Offset	ı	L	Trower ro	ss/ surge	L	Tottlet		

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio •Wednesday, October 03, 2012 2:53:25 PM

Page 1

Work Order ID:

90257

Parent Item:

D350-636-016

Parent Item Name:

Skidtube STD w/ Training Wearplates, RH

Start Date: 9/13/2012

Required Date: 9/28/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP rev:A 10.09.28 new issue DD verf:EC

IPP Rev:B 11.04.14 ecn11-553

DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-041		Manufactured	No				Each	2.0000		1			
Wearplate Assembly								2.000		<u>\\ </u>	ulsola	17	
				Location		Loc Oty	Lo	c Code					
				FP1		2							
				9029	8	2			x				
() Mcon	~ 02 cl	3					130	10373)				

(1x) MS21083. C8 / M122457 M uliolz

											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UPDA	ATE	·		•	
											QA Closed:	Date:		
Work Orde	or.					DISPOSITION	DISPOSITION AGAINST DEPARTMENT/P							
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root 4					Descri	ption of work order update	1	Initial	Actio	n	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	tion	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		_												
						F.	AUI	LT CATE	GORY					
Landi						General	_	7			1		٦	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs					Bend BOM/Route Broken/Damaged Burrs Contamination		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct " issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
ł	+	Heat Trea	t			Countersink		Mislabe	eled	į	Positioned Wrong			

Misread

Out of Calibration Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish Folio

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